Work Order ID 76218 Monday, November 07, 2011 2:42:5159

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Navi (100 € 5 × 100 € 1 N900040100* Setup Start Revision ID: Item Name: Lug Assembly 11/7/2011 Start Date: **Start Oty: 12.00 Cust Item ID: Required Date:** 11/16/2011 Reg'd Oty: 12.00 **Customer:** Reference: Start Run Date://-//-0 Process Plan: Tooling: Date:_ **Approvals:** Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Tool # Plan Reject Set Up/ Accept Reject Insp. Number **Work Center ID** Description Run Hours Code Qty **Qty** Stamp **Revision Nbr** Draw Nbr D3405 Rev B 100 0.00 FLOW WATER JET *100* B11-11-9 Waterjet 0.00 Memo 1-Cut as per Dwg D3405 Dwg Rev: D FLOW CNC Waterjet 304.125 Prog Rev: 2-Deburr if necessary QC2- Inspect parts off machine FAI/FAIB 0.00 110 *110* 131-11-9 0.00 Memo Quality Control 120 QC8- Inspect parts - second check 0.00 *120* Jululio OC Memo Quality Control

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W/O:			W	ORK ORDER CH	ANGES					
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NCR:		V	VORK OR	DER NON-CONFO	RMANCE	(NCF	₹)			
		Description of NC		Corrective Action	Section B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descrip Chief Eng	otion	Sign 8 Date	k Section		Chief Eng	QC Inspector
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Item ID: D3405 041 Revision ID:			Accept	*N9กก้	04010	n* s	Setup Start *	JS1*
Item Name: Lug Assemb	bly		1.61			•	Stop *	IS2 *
Start Date: 11/7/2011	Start Qty: 12.00	*12	・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・	Cust Item I	D:			
Required Date: 11/16/2011	Req'd Qty: 12.00	*/2	* ' //	Customer:			Jan ²⁰	
Reference:	*.				-		1	
Approvals: Process P	Plan:	Date:	Tooling:	Da	nte:	R	Run Start *	JR1*
QC:		Date:	SPC (Y/N):	· Da	nte:		Stop *	IR2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty	Reject Reject Qty Number	Insp. r Stamp
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<u>*130</u> *	NC BRAKE		2.22			(15)		
Brake NC	Memo		0.00	s 11 11 22				
Brake NC		g DT8204 as per Dwg D 81 to check if correct for	3405 mring	n/u/22	. 4'	. ₁		
•						/		
140	QC5- Inspect part comple	eteness to step on W/O	0.00			Λ	1	
1 <i>4</i> ∩					्रह	W	11 / 11 -	22/15
QC	Memo		0.00		•			
Quality Control		•			ूर्य अर्थ -			<u> </u>
150		•						

0.00

150 Large Fab

Large Fab

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Memo

Weld as per Dwg D3405 use DT8484 Identify as D3405-041

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Dart Aerospace Ltd W/O: **WORK ORDER CHANGES Approval Approval** DATE STEP PROCEDURE CHANGE By **Date** Qtv Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: ____ Resolution: _____ Disposition: ____ QA: N/C Closed: ____ Date: ____ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B Verification **Description of NC Approval Approval** DATE **STEP** Sign & **Action Description** Initial Section C Chief Eng QC Inspector Section A Date Chief Eng Chief Eng

Item (Da D3405-041) Revision (Da Lug Assembly			Accept	*N90004010	n^*	Setup Start Stop	*NS1* *NS2*
Start Date: 11/7/2011 Required Date: 11/16/2011 Reference:	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*	e e e e e e e e e e e e e e e e e e e	Cust Item ID: Customer:			
		te:	Tooling: SPC (Y/N):	Date:Date:		Run Start Stop	*NR1* *NR2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID Tool # Plan			Reject Insp. Number Stamp
*160 *160* QC Quality Control	QC9- Inspect visual per QSI004 Memo	- Fusion Welds	0.00	M. 11.	12.81	15	
170	QC5- Inspect part completeness	to step on W/O	0.00		Λ		, F
170 QC Quality Control	Memo		0.00		W	1)	12 01 (K)
180 *4.00*	White Gloss(Ref:4.3.5.2) per QS	51005 4.3-Steel	0.00		/<\/	\times M	11/12/02
180 Powder Coating	Memo START TIME: OVEN TEMPERAT FINISH TIME:	8 -/(TURE: 4	0.00 F		10xg	<i>01</i> 11/2	1-11-102

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NCR:		V	VORK OR	DER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	Section 1	tion C	Chief Eng	QC Inspector
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the state of the s	der ID 76218 mber 07, 2011 2:42:51 PM		*76218*								Page 4	
Item ID: Revision ID: Item Name:	D3405-041 Lug Assembly	V		Accept	*N9000	04 0	100) *	Setup	Start Stop	*N.	S1*
Start Date: Required Date: Reference:	11/7/2011	Start Qty: 12.00 Req'd Qty: 12.00	*1: *1:		Cust Item II Customer:) :					IN	5/
Approvals:		an:	Date:	Tooling: SPC (Y/N):	Date Date Date Date Date Date Date Date				Run	Start Stop	*N	R1*
Sequence ID/ Work Center II 190 *1 QC Quality Control		Operation Description QC3- Inspect Part Finish Memo		Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accep Qty	Qt	ty I	Reject Number	Insp. Stamp
200 *200* Packaging Packaging		ldentify as per dwg & Sto Memo	ck Location	478**0.00 0.00				(50	<u></u>	SP	[1]	12-0
210 *210* QC		QC21- Final Inspection -	Work Order Release	0.00				4	, \ II	12/02	۷	
Quality Control								W	(1	20		

W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC		Corrective Action Section			cation	Approval	Approval
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		on C	Chief Eng	QC Inspector
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Picklist Print

Monday, November 07, 2011. 2:42:56 PM

Work Order Da 76218

76218 *D3405-041*

Parent[Item: D3405-04] Parent Item Name:

Lug Assembly

Start Date: 11/7/2011

Required Date: 11/16/2011

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP A05.09.01New issueKJ/JLM

IPP B 09.01.28 rev.B drawing EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3404-1	AND THE RESERVE OF THE PARTY OF	Manufactured	No			100	Each	67.0000	1	12	2		
D3404-1	f								**	(pl	11.11	`3C)
,				Location		Loc	Oty	Loc Code					
				WA			7				_		
, /					70664		7		_		_		
				WA030			60				_		
					72326		13		7	15	-		
м304S11GA		Purchased	No	(74551	150	47 sf	103.8000	0.154	1.94526	3 3 ,6	5	
M304S11	GA								**	[B11-11-9		
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					119048		53.3		`				

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NCR:		V	VORK ORI	DER NON-CONFORMAN	ICE (NCF	₹)			
DATE	CTED	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	B Sign 8	k Secti	cation ion C	Approval Chief Eng	Approval QC Inspector
DATE	STEP	Description of NC Section A		Action Description	Sign	k Secti		Approval Chief Eng	Approval QC Inspector
DATE	STEP	Description of NC Section A		Action Description	Sign	k Secti		Approval Chief Eng	Approval QC Inspector
DATE	STEP	Description of NC Section A		Action Description	Sign	k Secti		Approval Chief Eng	Approval QC Inspector
DATE	STEP	Description of NC Section A		Action Description	Sign	k Secti		Approval Chief Eng	Approval QC Inspector
DATE	STEP	Description of NC Section A		Action Description	Sign	k Secti		Approval Chief Eng	Approval QC Inspector
DATE	STEP	Description of NC Section A		Action Description	Sign	k Secti		Approval Chief Eng	Approval QC Inspector
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DATE	STEP	Description of NC Section A		Action Description	Sign	k Secti		Approval Chief Eng	Approval QC Inspector
DATE	STEP	Description of NC Section A		Action Description	Sign	k Secti		Approval Chief Eng	Approval QC Inspector

DART AEROSPACE LTD	Work Order: 600 100 100 100 100 100 100 100 100 100	
Description: GHW Lug	Part Number:	
Inspection Dwg: D3405 Rev: B	Page 11 of 11	

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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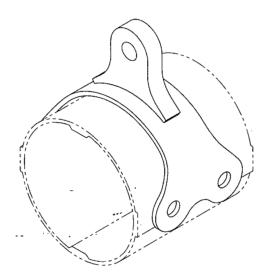
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.438	+0.006/-0.001	-442	9		V 1267	
1.50	+/-0.030	1.596	b		1	
1.750	+/-0.010	1.752	a		Ŭ	
6.751	+/-0.010	6749			V	
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Measured by:	Î2	Audited by:	8	Prototype Approval:	N/A
Date:	11-11-9	Date:	Mulio	Date:	N/A

Rev	Date	Change	Revised by Approved
Α	08.11.28	New Issue P/O D3405-041	KJ/EC
В	09.05.04	Dimensions update per Dwg Rev. B	KJ/DD 📢

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:			WORK ORD	ER NON-CONFORM	ANCE	(NCR))			
DATE	STEP	Description of NC Corrective Action Section			tion B		Verific	ation	Approval Chief Eng	Approval
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ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	* X		D3405-041	LUG ASSEMBLY
2,,,,,,,		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1	T	D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET



D3405-041 LUG ASSEMBLY (SKID TUBE SECTION SHOWN FOR REF ONLY)

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

D3405-043 LUG ASSEMBLY (SKID TUBE SECTION SHOWN FOR REF ONLY)

DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERED TO "B" SIZE BORDER. FLAT PATTENS FOR -1 & 3. INCRESSED IN LENGTH TO PREVENT FOULING AT INST. (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100. AJS 08.09.19 05.03.08 NEW ISSUE REV. DESCRIPTION DATE

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3405 MFG. APPR. SHEET 1 OF 4 TITLE SCALE APPROVED GHW LUG ASSEMBLY DE APPR COPYRIGHT © 2005 BY DART AEROSPACE LTD DATE 08.09.19

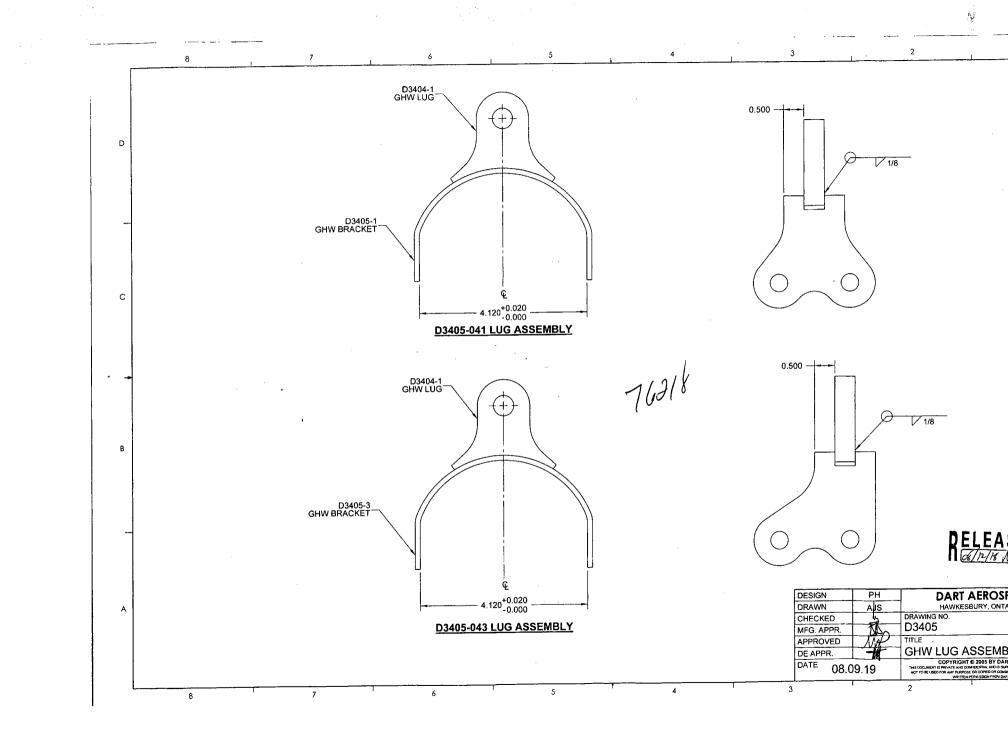
1) MATERIAL: N/A 1) MATERIAL, MA 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER : IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER

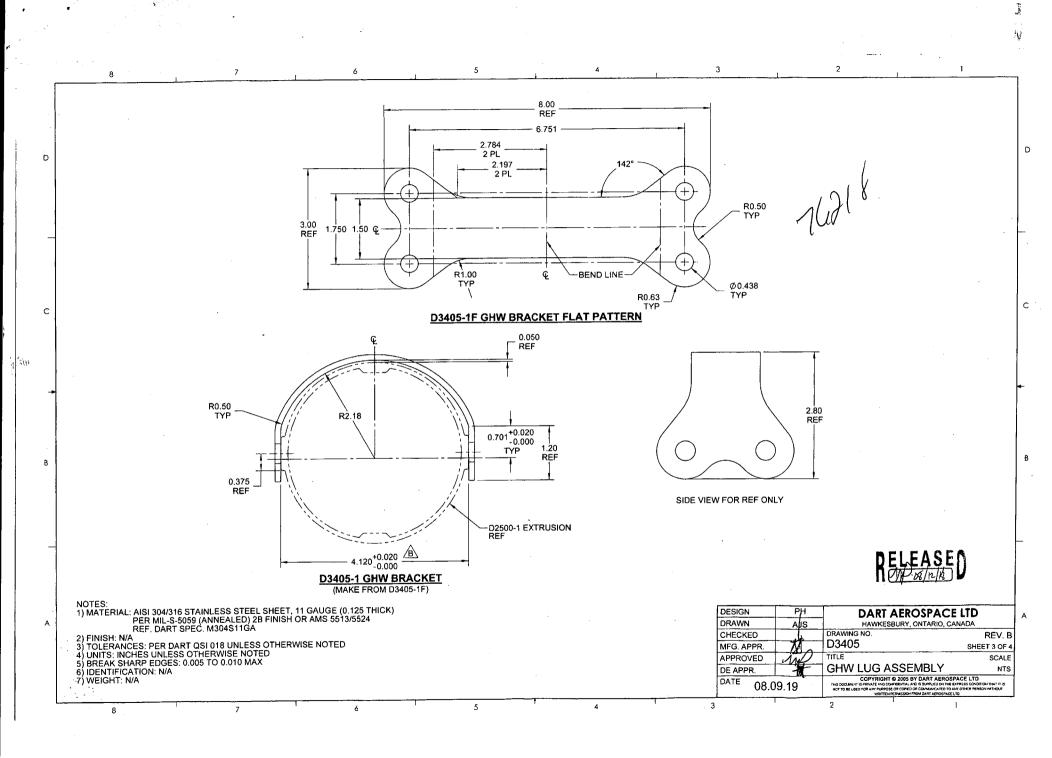
7) WEIGHT: -041, 0.85 lbs -043, 0.87 lbs

3

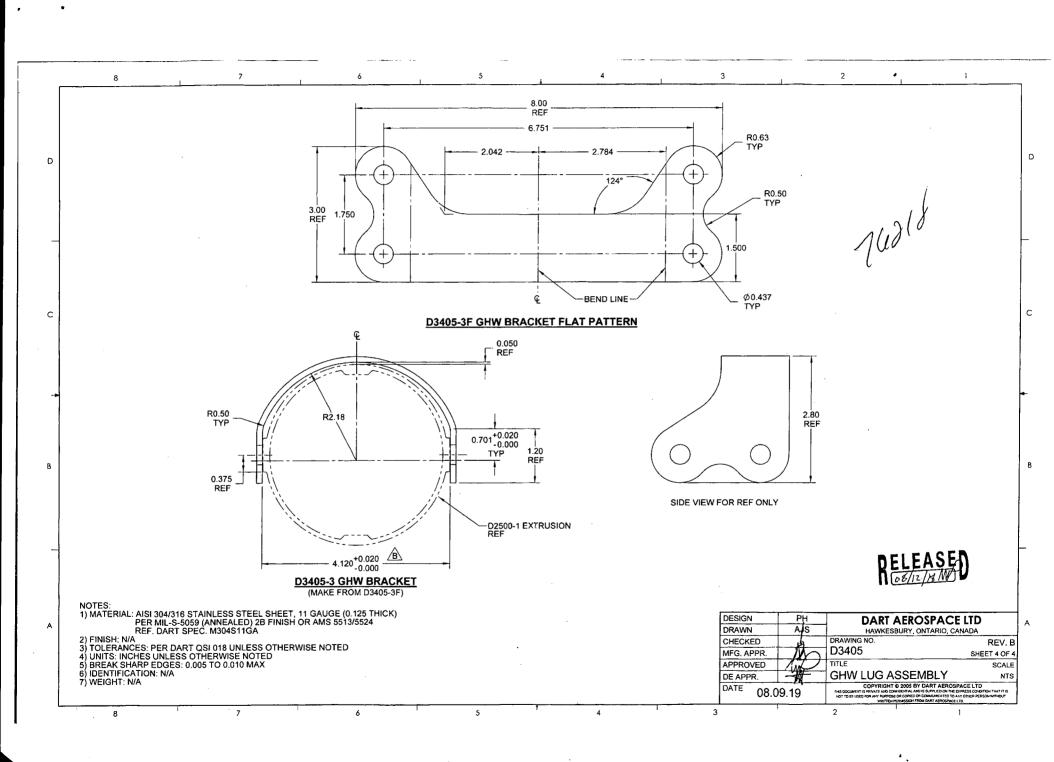
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DATE	SIEP								QC Inspector
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